

Work Order ID 64659

Monday, December 13, 2010 10:25:38 AM



Page 1

Item ID: D206-746-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Blower Motor Assembly

Start Date: 12/13/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/31/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: *10-12-13*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI9341

Rev C

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-746-043 CHG 001

N/A

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Change bearing - D3742-1 B Batch: *B48562*

Assemble as per dwg DSI 9341

Center punch set-screw, then drill as per dwg.

Add locktite 26221 to fan set screw batch: *M113436*

Secure using Lock Wire

A/R MS20995-025E LOCK WIRE Batch: *M18670*

Batch:

⇒ m-1 10/12/15

(1x)

PTD

TESTED MOTOR WITH DC unit
Ran for 12 hrs

10/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-746-043 PAR #: _____ Fault Category: Small Fms NCR: Yes No DQA: ✓ Date: 10.01.04
 Resolution: re-work Disposition: re-work QA: N/C Closed: ✓ Date: 11/01/04

NCR: <u>64659</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/12/17</u>	<u>100</u>	<u>wire has minor</u> <u>1 wire was damaged</u> <u>on the cover. wire not exposed.</u> <u>R.C. other.</u>	<u>10.12.17</u>	<u>re-cover with electric</u> <u>sheet shrink both</u> <u>wire</u> <u>n 116449</u>	<u>m-k</u> <u>10/12/17</u>	<u>8</u> <u>10/12/17</u>	<u>10.12.17</u> <u>64042</u>	<u>10/12/17</u>

NOTE: Date & initial all entries

Work Order ID 64659

Monday, December 13, 2010 10:25:38 AM

Page 2

Item ID: D206-746-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Blower Motor Assembly

Start Date: 12/13/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 12/31/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

8.10/12/17

④



QC

Memo

Quality Control

130

Packaging

0.00



Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D206-746-043

Location:

PPP Rev: 68787

PMP

C. 10/12/17 ①

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

10/12/2010

MF

10-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 13, 2010 10:25:38 AM

Page 1

Work Order ID: 64659

Parent Item: D206-746-043

Parent Item Name: Blower Motor Assembly





Start Date: 12/13/2010

Required Date: 12/31/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 06.08.21 New Issue EC
IPP rev B 07.03.15 DSI 9341 Rev B KJ
IPP Rev:C 08-02-12 change to rev.c DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
26D71  Blower Motor		Purchased	No			110	Each	1.0000	1	1			
<div> <div>Location</div> <div>ST</div> <div>115883</div> </div> <div> <div>Loc Qty</div> <div>1</div> <div>1</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
AN3-3A  Bolt		Purchased	No			110	Each	203.0000	6	6			
<div> <div>Location</div> <div>ST350</div> <div>115621</div> <div>116400</div> </div> <div> <div>Loc Qty</div> <div>203</div> <div>3</div> <div>200</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
AN960-10  Washer	NAS1149F0363P	Purchased	No			110	Each	7,883.000	6	6			
<div> <div>Location</div> <div>ST348</div> <div>19356</div> <div>5519</div> </div> <div> <div>Loc Qty</div> <div>7883</div> <div>200</div> <div>7683</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3471-041  Blower Motor Support		Manufactured	No			110	Each	2.0000	1	1			
<div> <div>Location</div> <div>ST159</div> <div>48304</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

m-f w/12/15

m-f w/12/15

m-f w/12/15

m-f w/12/15

~~B-48304~~ 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 13, 2010 10:25:38 AM

Page 2

Work Order ID: 64659

Parent Item: D206-746-043



Parent Item Name: Blower Motor Assembly

Start Date: 12/13/2010

Required Date: 12/31/2010



Start Qty: 1.00

Required Qty: 1.00

D3473-041	Manufactured	No	110	Each	3.0000	1	1
							<i>m-l 6/12/15</i>
Blower Inlet Adapter							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST160	3	
37114	3	

D3476-041	Manufactured	No	110	Each	4.0000	1	1
							<i>m-l 6/12/15</i>
Blower Motor Adapter							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST156	4	
45185	4	

D3477-041	Manufactured	No	110	Each	1.0000	1	1
							<i>m-l 6/12/15</i>
Blower Motor Inlet Adapter							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

WA	1	
36432	1	

D3585-1	Manufactured	No	110	Each	103.0000	2	2
							<i>m-l 6/12/15</i>
Set Screw							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST072	103	
31571	3	
55705	100	

D3742-1	Manufactured	No	110	Each	6.0000	2	2
							<i>m-l 10/12/15</i>
Bearing							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST086	6	
48562	6	

Monday, December 13, 2010 10:25:38 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, December 13, 2010 10:25:38 AM

Page 3

Work Order ID: 64659



Parent Item: D206-746-043



Parent Item Name: Blower Motor Assembly

Start Date: 12/13/2010

Required Date: 12/31/2010

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-04

Purchased

No

110

Each

266.0000

3

3



SCREW



m-l 12/12/15

Location

Loc Qty

Loc Code

ST290

266

109752

266

3

MS35333-38

Purchased

No

120

Each

90.0000

3

3



LOCK WASHER



m-l 12/12/15

Location

Loc Qty

Loc Code

ST295

90

107063 ✓

90

3

Monday, December 13, 2010 10:25:38 AM

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-746 REV. A
REF. CANADIAN STC: SH05-45 ISSUE 1
FAA STC: SH3367NM DATED OCT. 13, 2005

The Parts List of Installation Instructions IIN-D206-746 Rev. A should be amended as follows:

Qty -011	Qty -041	Qty -043	Part Number	Description
X			D206-746-011	SHROUD AIRFLOW HEATER SYSTEM
1	X		D206-746-041	REAR OVERHEAD PASSENGER MODIFICATION KIT
1		X	D206-746-043	BLOWER MOTOR ASSEMBLY
		1	D3471-041	BLOWER MOTOR SUPPORT (CAM-1984-008)
		1	D3473-041	BLOWER INLET ADAPTER (CAM-1984-013)
		1	D3476-041	BLOWER MOTOR ADAPTER (CAM-1984-014)
		1	D3477-041	BLOWER MOTOR INLET ADAPTER (CAM-1984-015)
		2	D3585-1	SET SCREW
		2	D3742-1	BEARING
		A/R	28221	LOCTITE 226 THREADLOCKER
		1	26D71	BLOWER MOTOR (26D71-1)
		6	AN3-3A	BOLT
		6	AN960-10	WASHER
		3	MS27039-08-04	MACHINE SCREW
		3	MS35333-38	LOCK WASHER
		A/R	MS20995-025E	LOCK WIRE

Furthermore, any mention of "Blower Motor Assembly" appearing in Installation Instructions IIN-D206-746 Rev. A, and Installation Drawing D206-746 Rev. A, should be replaced by D206-746-043 Blower Motor Assembly.

For assembly instructions of D206-746-043 Blower Motor Assembly, refer to page 2 of this DSI.

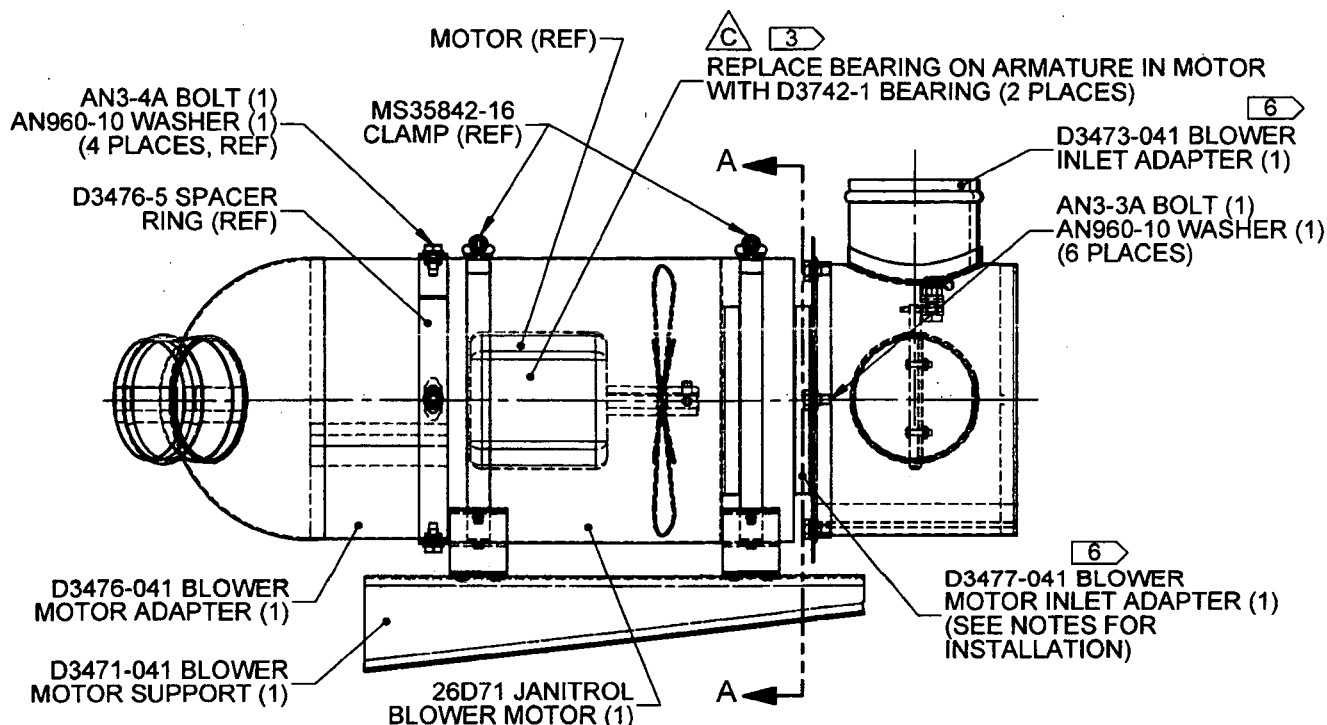
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

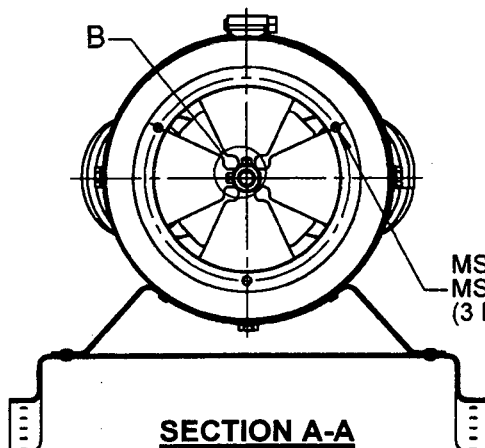
BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 08.01.20
CERT. NO.: SH05-45
ISSUE NO.: 1

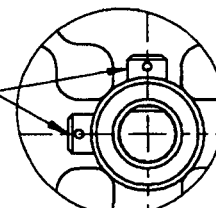
C	ADD D3742-1 BEARING; UPDATE FORMAT	PH	08.01.20
B	ADD D3585-1 & DETAIL B	MB	07.01.02
A	NEW ISSUE	MB	06.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN	<u>[Signature]</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>[Signature]</u>	DSI 9341	SHEET 1 OF 2
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	BLOWER MOTOR ASSEMBLY	NTS
DATE	08.01.20	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D206-746-043 BLOWER MOTOR ASSEMBLY



4
REPLACE EXISTING SET SCREWS WITH D3585-1 SET SCREWS (2), APPLY LOCTITE 226, TORQUE TO 50-70 in-lbs (5.6-7.9 N-m) AND SECURE USING MS20995-025E LOCK WIRE



DETAIL B
SCALE 1:1

1
MS27039-08-04 MACHINE SCREW (1)
MS35333-38 LOCK WASHER (1)
(3 PLACES)

INSTALLATION NOTES:

- 1) ON 26D71 BLOWER MOTOR, REMOVE EXISTING MACHINE SCREWS (3), LOCK WASHERS (3) AND EXISTING ADAPTER (1).
- 2) REMOVE MOTOR AND RETAIN HARDWARE
- 3) REPLACE BEARINGS WITH D3742-1 BEARINGS (2 PLACES) (3)
- 4) REPLACE SET SCREWS WITH D3585-1 SET SCREWS (2 PLACES)
- 5) RE-INSTALL MOTOR WITH HARDWARE REMOVED AT STEP 2
- 6) REPLACE ADAPTER WITH D3477-041 BLOWER INLET ADAPTER. USE HARDWARE REMOVED AT STEP 1 TO SECURE D3473-041/D3477-041 BLOWER INLET ADAPTER TO 26D71 JANITROL BLOWER MOTOR.
- 7) D206-746-043 IS SUPPLIED TO CUSTOMER PRE-ASSEMBLED

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 08.01.20

CERT. NO.: SH05-45

ISSUE NO.: 1

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DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	EE	DSI 9341	SHEET 2 OF 2
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